



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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12568

D2803-041

Job Sheet 189315



Part No: D2803-041

Job Qty: 3 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/11/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG D2803 REV C IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP REV:G 16.06.23 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	2/11/19		0.00	0.22	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		36
							Small Fab - 5		9-89
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	2/11/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		DAS
							QC 5 - 50		40
							QC 5 - 30		9-89
120	Powdercoat - 1 White Gl(A)-B4B	3 pcs	2/11/19		0.00	0.13	Powdercoat - 1 - B4B		
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		

130	QC 3	3 pcs	2/11/19	0.00 0.00	QC 3 - 10 QC 3 - 13 QC 3 - 15 QC 3 - 17 QC 3 - 18 QC 3 - 2 QC 3 - 26 QC 3 - 28 QC 3 - 3 QC 3 - 30 QC 3 - 34 QC 3 - 36 QC 3 - 38 QC 3 - 41 QC 3 - 51 QC 3 - 58 QC 3 - 59 QC 3 - 6 QC 3 - 68 QC 3 - 9	DAS 40 9-89
150	Small Fab - 2 - B4B	3 pcs	2/11/19	0.00 0.22	Small Fab - 1 - B4B Small Fab - 2 - B4B Small Fab - 3 - B4B Small Fab - 4 - B4B Small Fab - 5 - B4B Small Fab - 6 - B4B Small Fab - 7 - B4B	DAS 36 9-89
160	QC 5	3 pcs	2/11/19	0.00 0.00	QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 38 QC 5 - 42 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68 QC 5 - 9 QC 5 - 50 QC 5 - 30	DAS 40 9-89
170	Packaging 3-1 - Stock - B4B	3 pcs	2/11/19	0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B	DAS 40 9-89

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180	QC 21 - SA	3	2/11/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70

DAS

21 MAR 19 2019-88

Part Op 100 - (Small Fab) Press D2805-1 and D2809 into arm as per Dwg D2803

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 11:30 OVEN TEMPERATURE: 320°

FINISH TIME: 12:00 M 138997

130 - QC3- Inspect Part Finish

150 - (Small Fab) Assemble as per Dwg D2803.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2803-1	Bracket	3 Ea (1 ea)	100-Small Fab - 1	
D2805-1	Stop	3 Ea (1 ea)	100-Small Fab - 1	
D2809	Washer	3 pcs (1 ea)	100-Small Fab - 1	
AN3C16A	Bolt	6 Ea (2 ea)	150-Small Fab - 2 - B4B	
D3672-15	Phenolic Washer	12 pcs (4 ea)	150-Small Fab - 2 - B4B	
MS21043-3	Nut	6 Ea (2 ea)	150-Small Fab - 2 - B4B	

F162359 @ 5097206
 5043645 (24)
 5146049
 1/13/2018 8:30 AM 5057495 X2
 5042894
 5143711

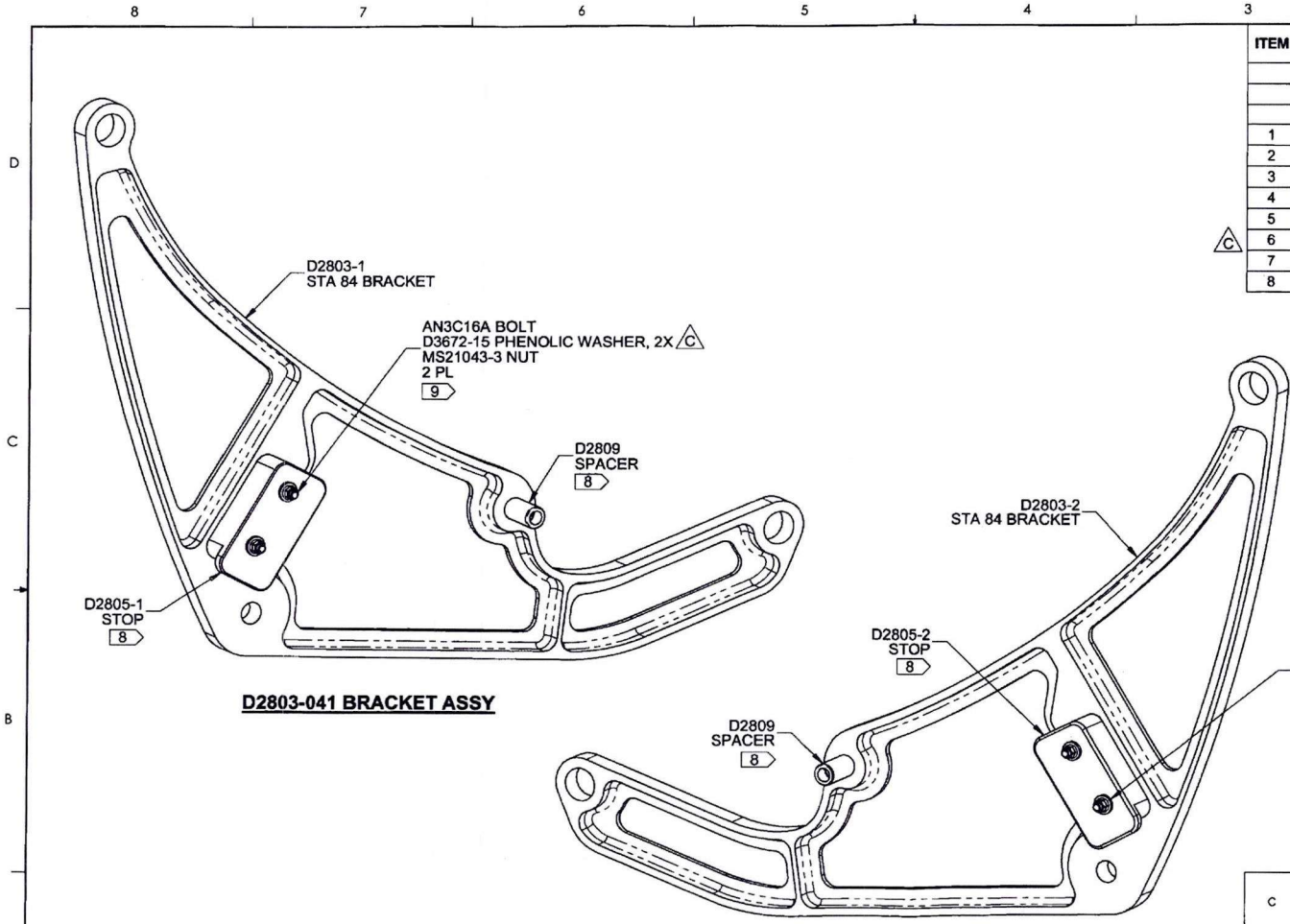
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2803-1	3	4	0
	D2805-1	3	13	0
	D2809	3	47	0
	AN3C16A	6	54	0
150-Small Fab - 2 - B4B	D3672-15	12	544	0
	MS21043-3	6	723	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2803-041	BRACKET ASSY
		X	D2803-042	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2803-041 BRACKET ASSY

D2803-042 BRACKET ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.58 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

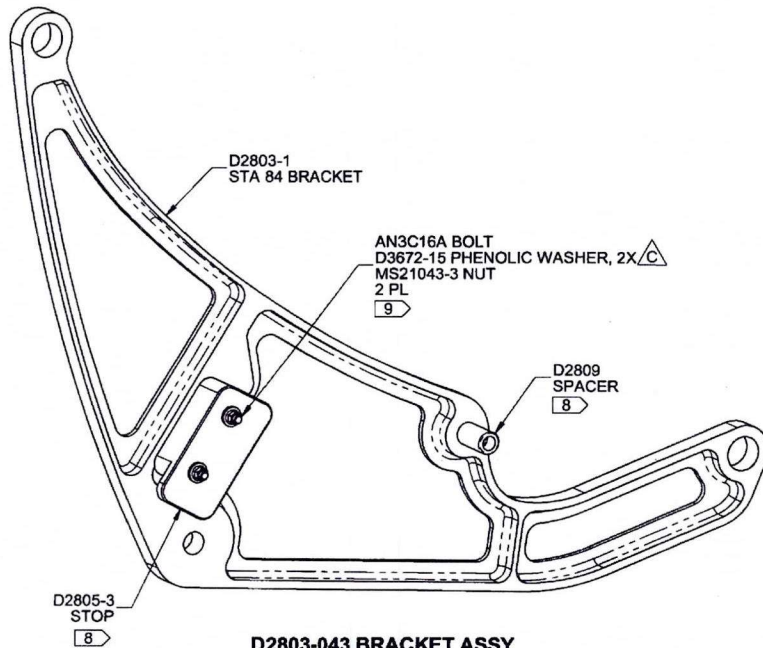
RELEASED
2016 JUN 22
ECN 16-661

C	REVISE TO CURRENT FORMAT; ADD DETAILS A AND F AND SECTION E-E; D3672-15 WAS NAS1515H3. ZONES C3-3/C6-4 AND B3-3/B6-3. 2.856 WAS 2.854 AND 0.438 WAS 0.437; REASON: CAD ERROR.	MB	16.04.11
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2803 TITLE STA 84 BRACKET REV. C SHEET 1 OF 4 SCALE NTS	
DRAWN	MB		
CHECKED	ML		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS		
DATE	16.04.11		

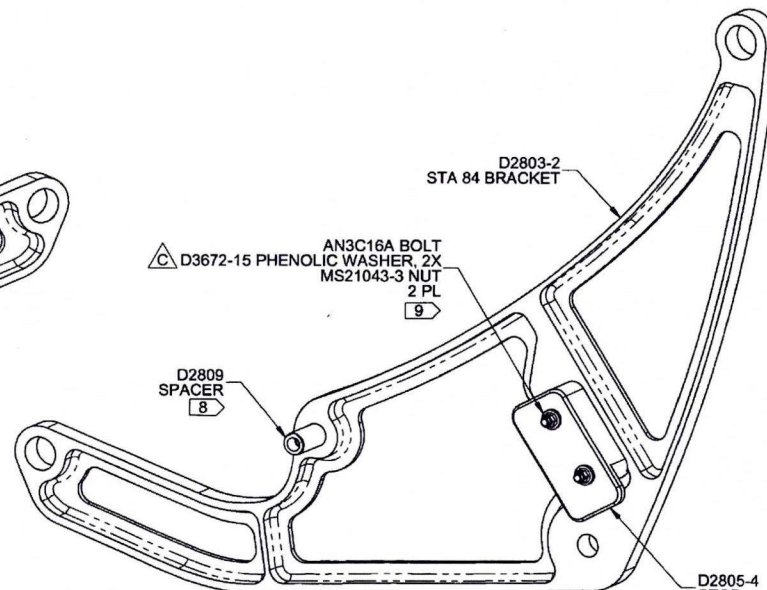
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APPROVED

ITEM	QTY -043	QTY -044	P/N	DESCRIPTION
	X		D2803-043	BRACKET ASSY
		X	D2803-044	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-3	STOP
4		1	D2805-4	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2803-043 BRACKET ASSY



D2803-044 BRACKET ASSY

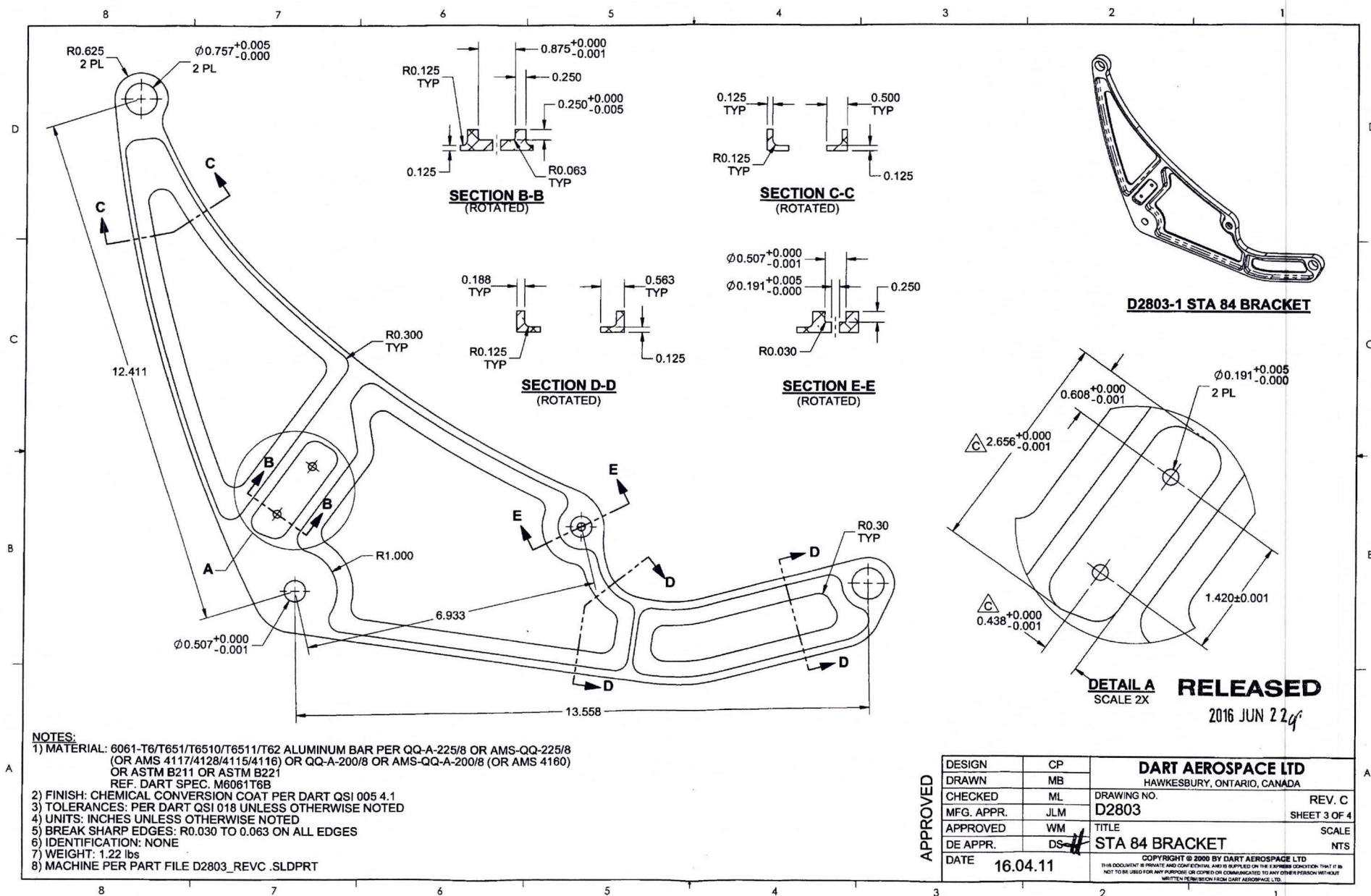
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2016 JUN 22 *up*

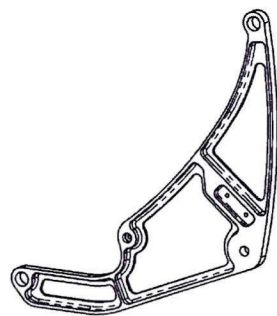
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.58 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

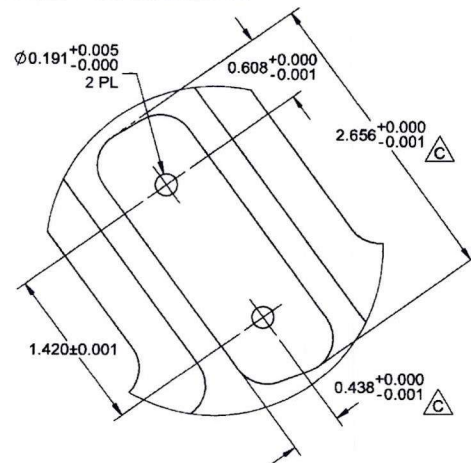
APPROVED	DESIGN	CP	DART AEROSPACE LTD	
	DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	ML	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D2803	SHEET 2 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 84 BRACKET	NTS
	DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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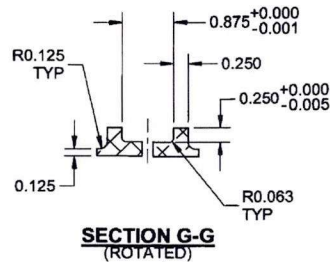
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	DRAWN	MB		
	CHECKED	ML	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D2803	SHEET 3 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 84 BRACKET	NTS
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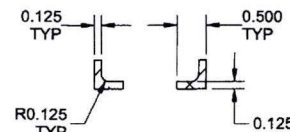
D2803-2 STA 84 BRACKET



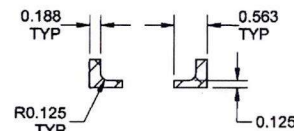
DETAIL F
SCALE 2X



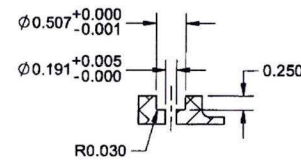
SECTION G-G
(ROTATED)



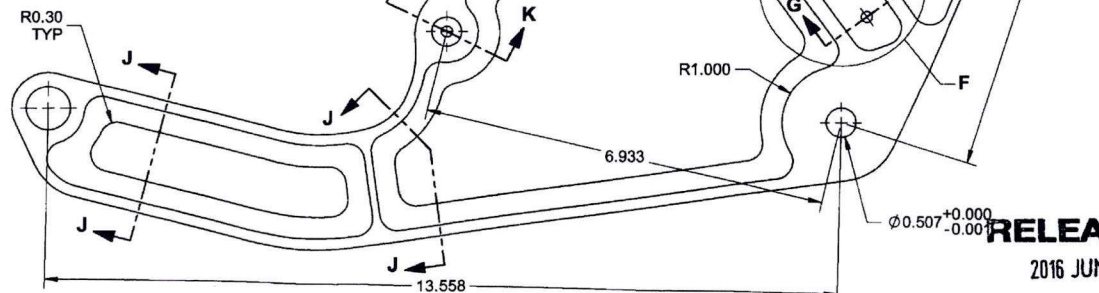
SECTION H-H
(ROTATED)



SECTION J-J
(ROTATED)



SECTION K-K
(ROTATED)



RELEASED
2016 JUN 22

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs
- 8) MACHINE PER PART FILE D2803_REVC.SLDPRT

APPROVED	DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	MB		
	CHECKED	ML	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D2803	SHEET 4 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 84 BRACKET	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

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Markham, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S161473

Part: D2803-041

Job No: 189315

Serial No/Batch: S161473

Revision:

Inspector:

Exp Date:

Instructions:

Various STC's

Date: 03/12/19